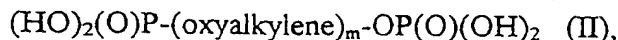
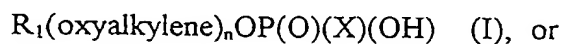
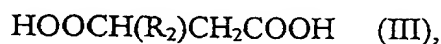


Claims

1. A method for the mechanical working of metals and alloys, characterised in that the method is performed in the presence of an aqueous cooling lubricant having a pH of 6-10 and containing a phosphate ester of the formula



where R_1 is an alkyl group with 1-12 carbon atoms, oxyalkylene is a group containing 2-4 carbon atoms, n is a number from 1-20, X is hydroxyl, $R_1\text{O}$ or $R_1(\text{oxyalkylene})_n\text{O}$, where R_1 , oxyalkylene and n have the meanings mentioned above, and m is a number from 4-40, or a salt thereof, and a carboxylic acid of the formula



where R_2 is an aliphatic group with 4-10 carbon atoms, or a salt thereof, or a mixture of any of the compounds I, II and III.

2. Method according to claim 2, characterised in that R_1 contains 2-8 carbon atoms and the group $(\text{oxyalkylene})_n$ contains at least partially oxypropylene units and n is a number from 4-15.

3. Method according to claim 2, characterised in that the phosphate ester of formula I is n -butyl- $(\text{C}_3\text{H}_6\text{O})_{10}\text{OPO}_3\text{H}_2$.

4. Method according to any of the claims 1-3, characterised in that the phosphate ester of formula II is $(\text{HO})_2(\text{O})\text{P}-(\text{oxypropylene})_{8-15}\text{OP(O)}(\text{OH})_2$.

5. Method according to any one of claims 1-4, characterised in that R_2 in formula III is octenyl, decenyl, diisobutenyl or tripropenyl.

6. Method according to any one of claims 1-5, characterised in that the total amount of compounds I and II is from 0,2 to 5% by weight and the amount of compound III is from 0,2 to 5% by weight.

7. Method according to claim 6, characterised in that the total amount of compounds I and II is from 0,4 to 3% by weight and the amount of compound III is from 0,4 to 3 % by weight.

8. A concentrate, characterised in that it contains
 anionic compounds I, II and III according to claims 1-5 20-95% by weight
 additional corrosion inhibitors 0-30% by weight

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additional lubricants

0-30% by weight

water

5-80% by weight

other ingredients

0-30% by weight,

the weight ratio between the compounds I and/or II and compound III being from 1:15 to 15:1

9. Concentrate according to claim 8, characterised in that it contains

the anionic compounds I, II and III 50-90% by weight

the additional corrosion inhibitors 0-15% by weight

the additional lubricants 0-15% by weight

water 10-50% by weight

the other ingredients 0-15% by weight,

the weight ratio between the compounds I and/or II and compound III being from 1:5 to 5:1.

10. Concentrate according to claim 8 or claim 9, characterised in that the total amount of the additional corrosion inhibitors, the additional lubricants and the other ingredients is from 5 to 40% by weight.

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